Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-53 **Date Opened:** 05 April 16 **Title:** Assembly

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket, Build/ Assemble **Product Model:** Ski **Quantity:** 1

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket	JC
70405	4	Lid Walkway	JC
84255	2	Handle Installation	JC
84261	2	Handle Assembly	JC
84240	0	Lid Brace Installation	JC

Traveller

	Initial or N/A
Install walkway on lid	DB
Install lid on basket body	DB
Re-tap mounting lug holes and install mount lugs	DB
Install handle brackets	DB
Install handle	DB
Install lid prop	DB
Install data plate	DB

Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	JC
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:	Print: Andrew Bartfai	Sign:	SCA: AD07	Date: 07-Apr-16
ICC / Dual Inspection preformed by:	Print: Jeff Clarke	Sign:	SCA: AD02	Date: 07-Apr-16
Work Order closed by:	Print: Jeff Clarke	Sign:	SCA: AD02	Date: 07-Apr-16

Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: 94012-01
Aircraft: Eurocopter Model: AS350
Description: Lid
Supplier: Aero Design
Color: White
WO#: 2015-136 PO#N/A

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2016-53

Date Open: 05 APR 2016

1. Lid Assembly — AD-07
    a. Install lid bumpers on bottom.
        i. Fill bumper holes with RTV silicone sealant.
        ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

    b. Install placard on bracket on top of lid.
        i. Locate placard on bracket.
        ii. Drill #30 through placard and bracket, using holes in placard.
        iii. Remove placard and de-burr holes in placard and on bracket.
        iv. Locate placard on bracket, and cleco in place.
        v. Rivet placard with four CR3213-4-02 CherryMax rivets.

    c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
        i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
        ii. Pull tread plate from stock. Shear tread plate to length.
        iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
        iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
        v. Mark and drill #30 holes:
            1. 0.25" from edge of tread plate, centre on cross members (0.38")
            2. 0.25" from edge of tread plate, middle of each walkway stringer
        vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using ¼" piloted counter bore on both sides.
        vii. De-burr holes in lid tubes.
        viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
        ix. Set tread plate in place, secure with clecos if necessary.
        x. Rivet placard with CR3213-4-02 CherryMax rivets

    d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly — AD-07
    a. Install attachment fittings
        i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
        ii. Run 3/8-24 tap into attachment lugs to clear threads.
        iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
        iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
            1. 90610 (Robinson R44) basket only:
                a. Install 1 fitting 906?? in lower forward attachment lug only.
                b. Install 3 96710-01 fittings in remaining locations.
        v. Torque to ??

b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
   i. Locate 94621-01 Brace over aft cross tube cutout
   ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
   iii. Torque AN4 bolts to ??

c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation AD-07
   a. Prepare hinge.
      i. Cut hinge to length:
         1. 776, 906 – 54"
         2. 751, 803 – 70"
         3. 698, 764, 945 – 72"
         4. 784 – 90"
         5. 940, 946, 959 – 95"
      ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.

   b. Install hinge on basket
      i. Locate hinge on basket (standard baskets)
         1. centre fore/aft
         2. 0.15" – 0.18" up from bottom edge
      ii. Locate hinge on basket (extra wide baskets)
         1. centre fore/aft
         2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
      iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
      iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
      v. Remove hinge and de-burr holes in hinge and basket rim.
      vi. Cleco hinge to basket with 5/32 clecos.
      vii. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

   c. Install lid on basket
      i. Locate lid on hinge (all baskets)
         1. center fore/aft
         2. 0.15" – 0.18" down from top edge
      ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
      iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
      iv. Remove hinge and de-burr holes in hinge and lid rim.
      v. Cleco lid to hinge with 5/32 clecos.
      vi. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle AD-07
   a. Install handle brackets.
      i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
      ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
      iii. Torque AN3 bolts to ??.

   b. Install handle
      i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
      ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
      iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
      iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
      v. At first end, remove bolt and repeat step iv.
      vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
      vii. Torque AN3 bolts to ??.

   c. Check handle
      i. Operate handle to ensure handle does not bind and springs hold handle in.
      ii. Snap handle into brackets to ensure handle locks.

   d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace AD-07
   a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
   b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
   c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
   d. Ensure brace is seated on lip of bushings before tightening nuts.
   e. Torque AN3 bolts to ??
   f. Record PO/WO of all parts used in steps above on attached material tracking list.

Complete
(initial or SCA#)

6. Final Inspection

   Dual inspection by a different person than assembled the basket.

   a. Check for general condition and correct assembly:
      i. Bolts are tight
      ii. Rivets are installed correctly
      iii. Handle operates correctly
      iv. Lid brace operates correctly
   b. Check that PO/WO numbers have been recorded.

2016-53
AS 350 XL ASSEMBLY
W/W ON LID

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69810, Revision 3 – Standard Low Mounted Basket
94510, Revision 0 – Extra-Wide Low Mounted Basket
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77610, Revision 1 – Short Basket
76410, Revision 3 – Medium Basket (left or right)
78410, Revision 2 – Long Basket
94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80210, Revision 0 – Short Basket
80310, Revision 0 – Medium Basket
81110, Revision 0 – Long Basket

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket

MD600
82811, Revision 0 – Standard Basket

Options
70405, Revision 3? – Lid Walkway

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-53 **Complete** (initial or SCA #)

Date Open: 05 APR 2016

1. Weld Lever Assembly – handle lever jig required — Previously C/W AD-05
   a. Set MS20615-4M3 monel rivet into socket in jig
   b. Set 36274-01 bushing into socket in jig
   c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
   d. TIG weld around bushing using ER308L rod.
   e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
   f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
   g. Record material POs on attached material list.

2. Clean up — AD-07
   a. Clean lever assembly by media blasting with glass bead.
   b. Drill out lever bushing to O (0.316) on lathe:
      i. Grasp bushing in chuck, ensure rivet clears between the jaws.
      ii. Run at 300 RPM.
      iii. Apply a drop of Rapid-Tap to drill.
   c. De-burr.

3. Fabricate Handle Assembly — AD-07
   a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
   b. Measure across TOP side of levers.
   c. Cut handle tubing to length measured.
      i. Handles under 40" long: 1.0" x 0.035 round tube
      ii. Handles over 40" long: 1.0" x 0.065 round tube
   d. De-burr tube.
   e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
   f. Record material PO on attached material list.

4. Weld Handle Assembly — AD-05
   a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up — AD-07
   a. Clean welded area with scotch-brite.

6. Final Inspection – DK
   To be completed by a different person than the previous steps.
   a. Welds for complete and handle for fit.
   b. Tag complete and inspected parts in preparation for installation.

Work Order: 2016-53

Date Opened: 05 APR 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		94010-01	**Cargo Basket Assembly**	S/N 94001-59	
Step 1				*Lid Assembly*		
	. 1		94012-01	Basket Lid Assembly		2015-136
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	. . 4		CR3213-4-02	Cherry Rivet		15086
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	15056
	. . A/R		CR3213-4-02	Cherry Rivet		15031
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				*Basket Assembly*		
Step 2.a.	. 1		94011-01	Basket Body Assembly		2015-136
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		AN960-616	Washer		
Step 3				*Hinge Installation*		
	. 1		MS20001P4	Piano Hinge	95"	15069
	. 8		CR3523-5-02	Cherry Rivet		16005
	. A/R		CR3213-5-02	Cherry Rivet		15086
Step 4	. 1		84255-01	*Handle Installation*		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, ¾" Sheet	2016-37
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: 2016-53

Date Opened: 05 APR 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	. . 1		84261-01	Handle Assembly		See attached
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	
	. . 2		AN3-12A	Bolt		
	. . 4		NAS1149F0363P	Washer		
	. . 2		MS21044N3	Nut		
Step 5				*Lid Brace Installation*		
	. 1		36280-01	Brace Assembly		2016-32
	. 1		AN3-15A	Bolt		14084
	. 1		AN3-17A	Bolt		13084
	. 2		AN970-3	Washer		15014
	. 3		NAS1149F0363P	Washer		16005
	. 2		MS21044N3	Nut		15086
Step 6				*Inspection*	*None*	

Work Order: 2016-53

Date Opened: 05 APR 2016

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Handle Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	84261	**84261-01**	**Handle Assembly**		
Step 1				*Weld Lever Assembly*		2015-122
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
Step 2				*Clean Up*	*None*	
Step 3				*Fabricate Handle Bar*		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	14103
Step 4				*Weld Handle Assembly*	*None - Fuse weld, no rod req.*	
Step 5				*Clean Up*	*None*	
Step 6				*Inspection - Final Assembly*	*None*	

Aero Design

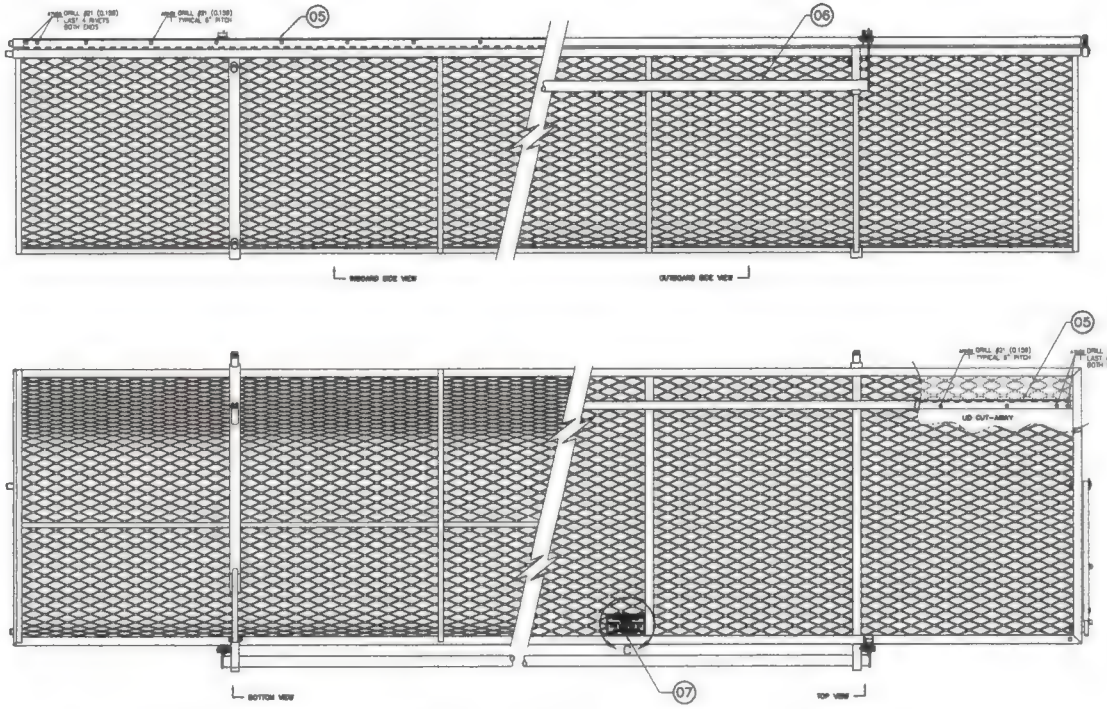
Parts Distribution Sheet

Description: Handle Bar Installation Kit WO#

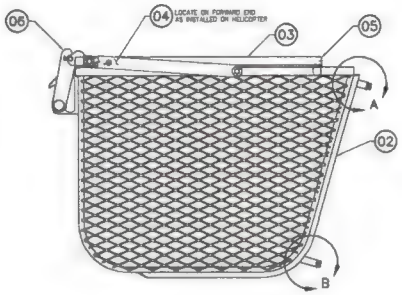
From PO or WO #	Quantity	Description	Part Number	For WO #
15075	4	Stud Fitting	96710	
15074	8	Washer	NAS1149F0663P	
14068	4	Bolt	AN3-11A	
13084	2	Bolt	AN3-12A	
2016-17	2	Brass Bushings	36275-01	
15031	12	Washer	NAS1149F0363P	
15031	6	Nut	MS21044N3	
15071	1	Spring	36278-01L	
15071	1	Spring	36278-01R	
15025	4	Bumper	M1417705	

2016-53

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK, ADD ALTERNATE RIVETS, HARDWARE P/NS UPDATED CHANGE BRACE ASSEMBLY TO INSTALLATION	BJC	11/07/2014



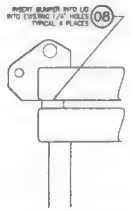
940 10 -01 CARGO BASKET ASSEMBLY – RH



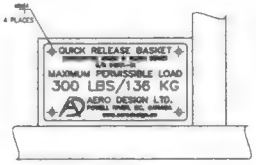
DETAIL A
SCALE 1 2
TYPICAL FRONT AND REAR

DETAIL B
SCALE 1 2
TYPICAL FRONT AND REAR

NOTE
1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



BUMPER INSTALLATION
SCALE 1 1



DETAIL C
SCALE 1 1
LOOKING AT PLACARD BRACKET

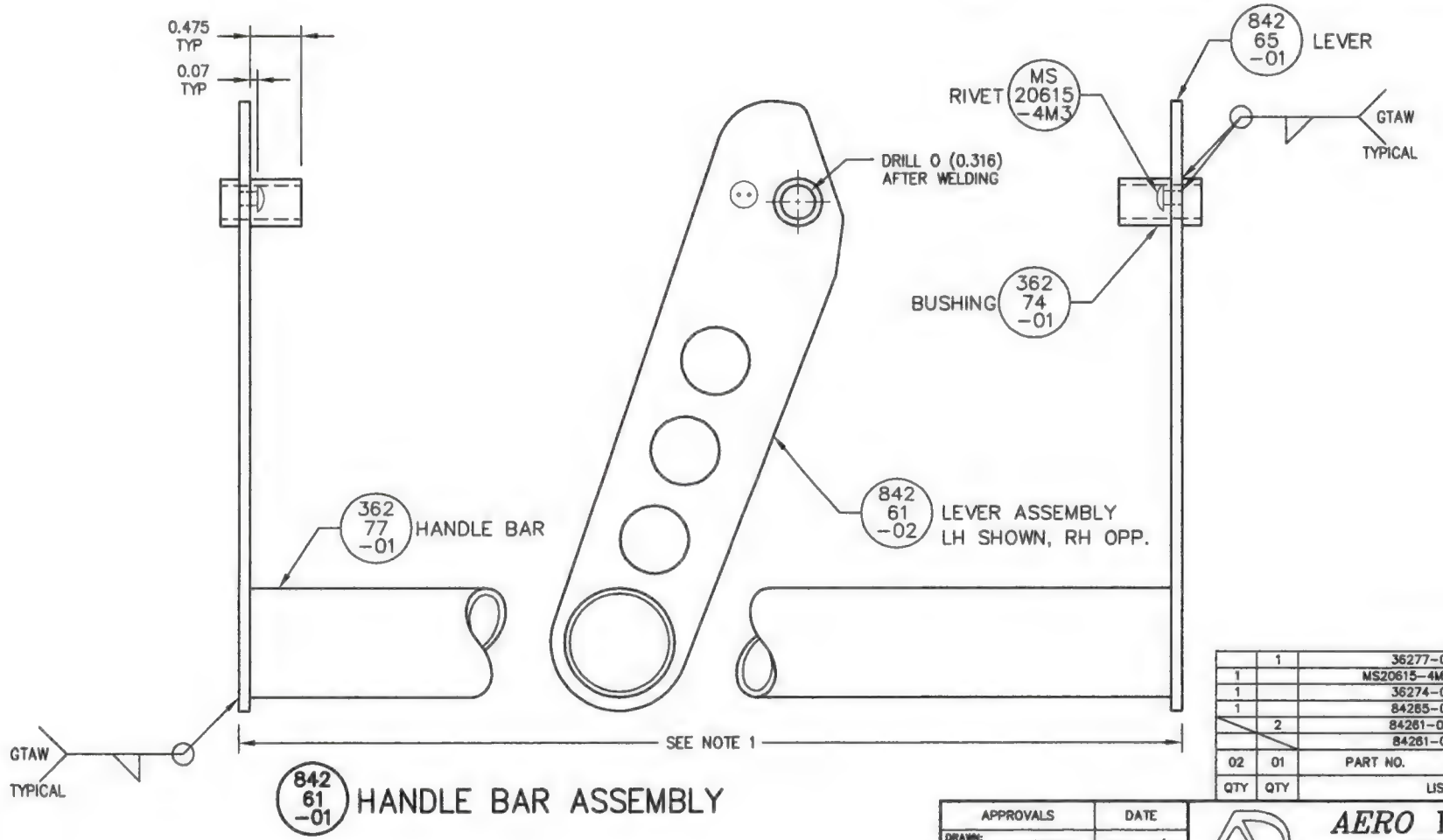
A/R	NAS1149F0863P	WASHER			
4	86710-01	FITTING	ALTERNATE: ANORA 400BE-14		
8	CR3523 5-02	CHERRY RIVET	ALTERNATE: HUCKMAX HR3523-5-02		
A/R	CR3213 3-02	CHERRY RIVET	ALTERNATE: HUCKMAX HR3213-3-02		
4	CR3213-4-02	CHERRY RIVET	ALTERNATE: HUCKMAX HR3213-4-02		
4	48205 4 08	BUMPER	ARGUS INDUSTRIES		
1	94027 01 07	PLACARD			
1	84255 C 06	HANDLE BAR INSTALLATION			
1	MS20001DY4	05	PIANO HINGE		65 INCHES LONG
1	94240 01 04	LID BRACE INSTALLATION			
1	84012 01 03	BASKET LID ASSEMBLY			
1	84011-01 02	BASKET BODY ASSEMBLY			
1	84010-01	CARGO BASKET ASSEMBLY			
QTY	PART NO.	ITEM DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

BASIC CODE (IF NAS 522)	DASH NO. FOR DIAMETER R=RIVET HEAD NEAR SIDE	APPROVALS	DATE	AERO DESIGN LTD. 10006a KALASPINA ROAD POWELL RIVER, BC. CANADA, V8A 0G3 TEL: 604.485.2576 www.aerodesign.ca
C=COUNTERSUNK D=DIMPLE	DASH NO. FOR LENGTH	Drawn R. RATHBEL	20 OCT 2011	EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET ASSEMBLY (EXTRA LARGE)
DIGIT=# OF SHEETS TO BE DRAWN		CHECKED E. BURDON		
BASIC CODES: BJ = MS20470AD, BR = MS20426AD, ARN = CR3213, ATM = CR3523	INSTALL NEW RIVET; REMOVE/REPLACE RIVET; EXISTING RIVET	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS X.XXX ±0.010, X.XX ±0.03, X.X ±0.1; ANGLES ±1/2°		SCALE 1 4 / SIZE A0 / DWG NO. 94010 / REV 1 / SHEET 1 OF 1

2016-53

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



842 61 -01 HANDLE BAR ASSEMBLY

NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

02	01	PART NO.	DESCRIPTION
QTY	QTY	LIST OF MATERIALS	
	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
	2	84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.488.8376 www.aerodesign.ca

HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY

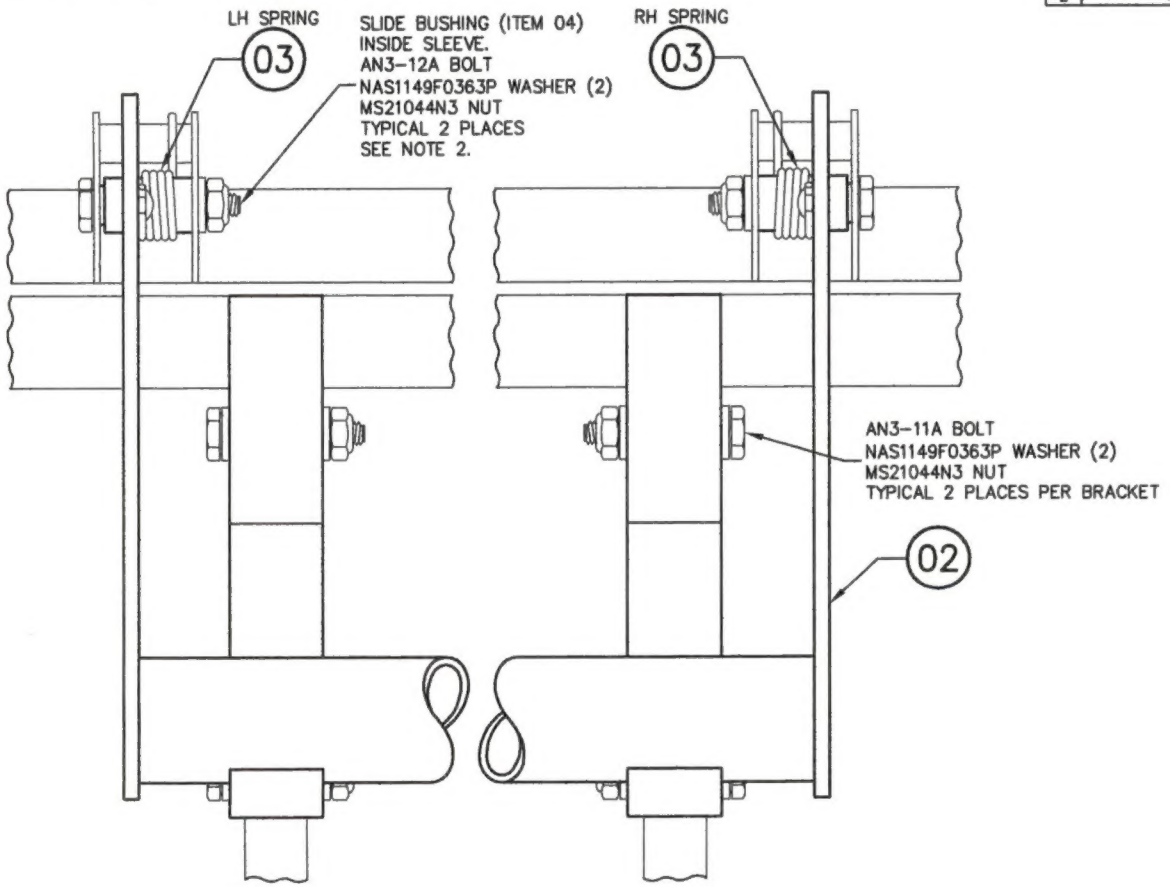
SCALE	DWG. SIZE	DWG. NO.	REV.
1 : 1	A3	84261	2
SHEET 1 OF 1			

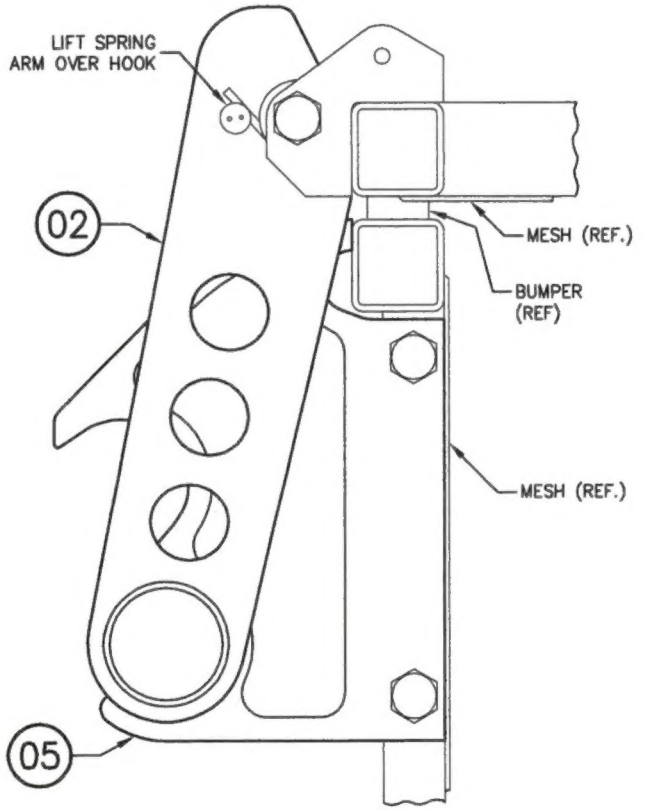
2016-53

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14





(01) HANDLE INSTALLATION

A/R	PART NO.	ITEM	DESCRIPTION	MATERIAL
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F

QTY. — LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

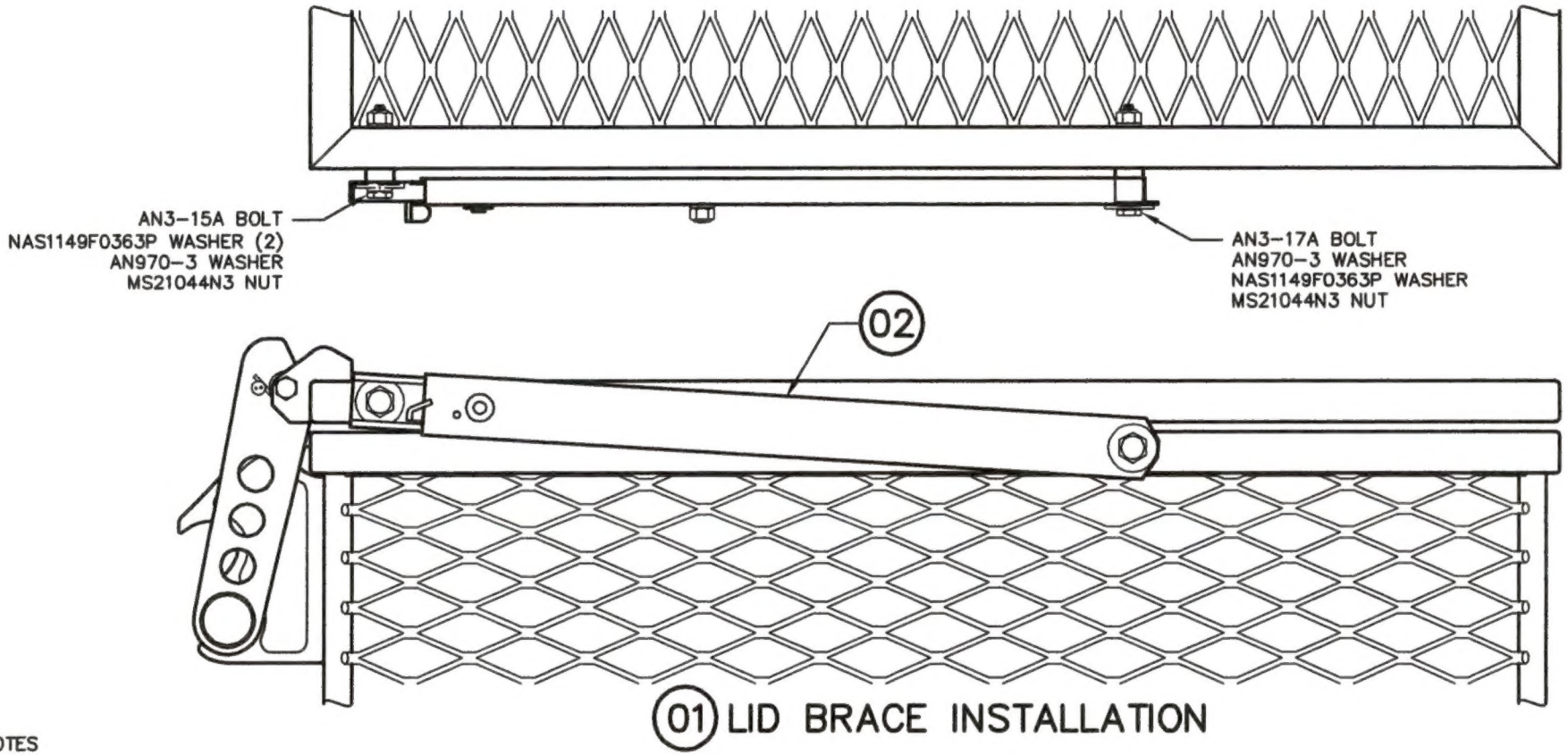
AERO DESIGN LTD.
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

2016-53

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 LID BRACE INSTALLATION

NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
   LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

QTY.	PART NO.	ITEM	DESCRIPTION
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	JEFF CLARKE	21 MAY 2014
CHECKED:	JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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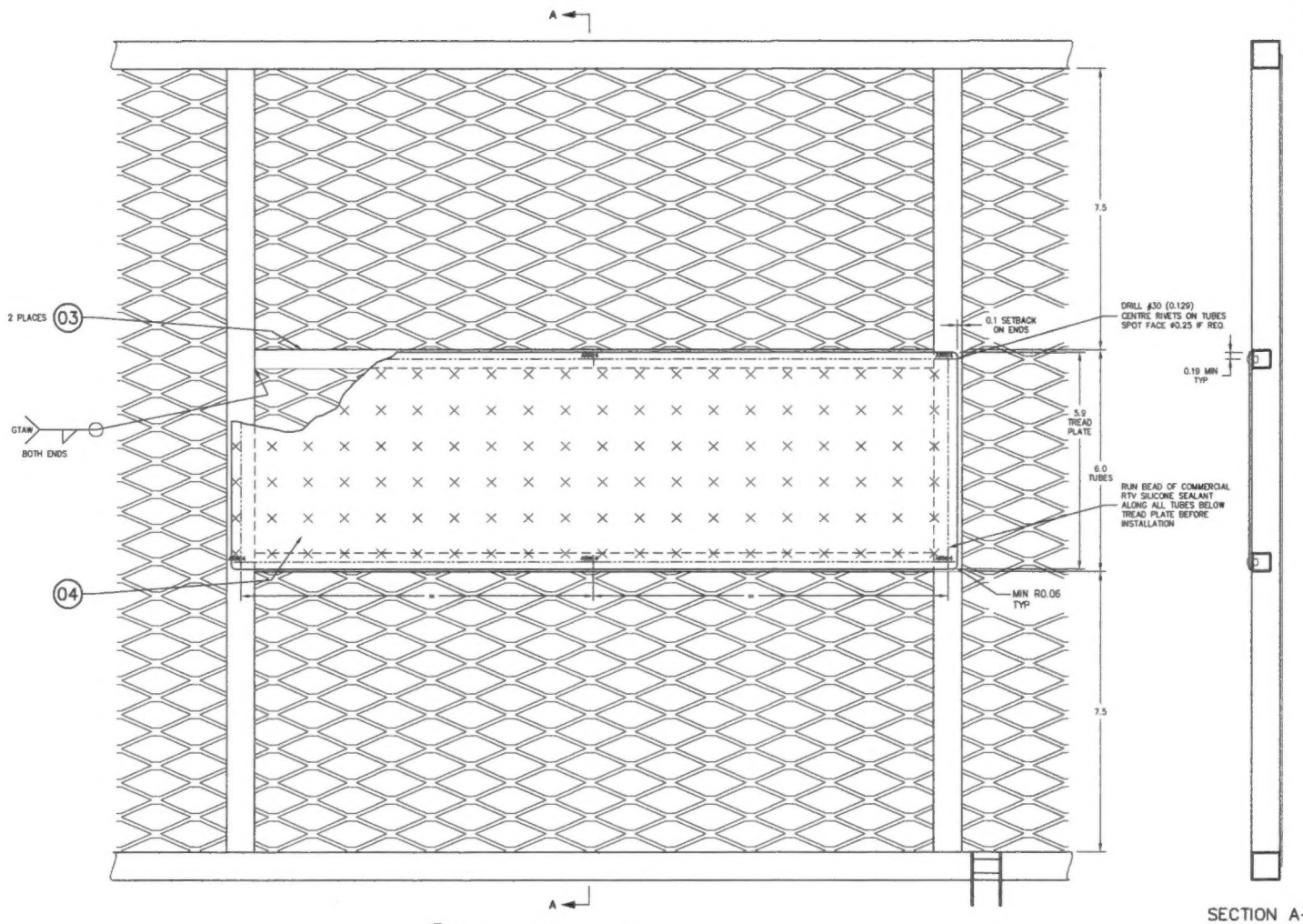
TEL: 604.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
ALL MODELS
LID BRACE INSTALLATION

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

2016-53

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014



01 BASKET LID ASSEMBLY

SECTION A–A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
A/R	CR3213-4-02		BLIND RIVET	ALTERNATE: HR3213-4-02		
1	70405-04	04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03	TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02	BASKET LID ASSEMBLY			
\	70405-01	01	BASKET LID ASSEMBLY – MODIFIED WITH STEP			

BASIC CODE REF. MAS 523

DASH NO. FOR DIAMETER
N=MFD. HEAD NEAR SIDE
F=MFD. HEAD FAR SIDE

C=COUNTERSUNK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED

DASH NO. FOR LENGTH

BASIC CODES:
BJ=MS20470AD
BB=MS20426AD
ARN=CR3213
ARM=CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS		DATE
DRAWN:	JEFF CLARKE	21 SEPT 2006
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

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POWELL RIVER, BC, CANADA, V8A 0C3
TEL: 604.483.3378 www.aerodesign.ca

CARGO BASKET
LID STEP MODIFICATION

SCALE 1 : 1.5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	70405	4

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2016-53-1

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2016-53

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94010-01	1	94001-59	New

12. Remarks

Modified with walkway on lid IAW DCL704

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12.

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	05 Apr 2016		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.